

Work Order ID 73473



Page 1

Thursday, September 01, 2011 7:37:57 AM

Item ID: D4419-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Support Plate

Start Date: 8/31/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: CL Date: 11/09/01

Tooling:

Date:

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4419	A								

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

304.128

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

1311-9-7



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

1311-9-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73473

Thursday, September 01, 2011 7:37:57 AM



Page 2

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Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Sub 2/08



130

Identify as per dwg & Stock Location: SI 139 H 0.00

Packaging

Memo

0.00

Packaging



11-09-08

140

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

11/9/08

MF 11-09-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, September 01, 2011 7:37:55 AM

Page 1

Work Order ID: 73473

Parent Item: D4419-3

Parent Item Name: Aft Support Plate




Start Date: 8/31/2011

Required Date: 9/16/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A NEW ISSUE 11-07-11 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA  304/316 0.125 Sheet		Purchased	No				sf	43.5000		2.910316			



91-9-7

Location

Loc Qty

Loc Code

MAT020

43.5

117494

43.5

117494

8

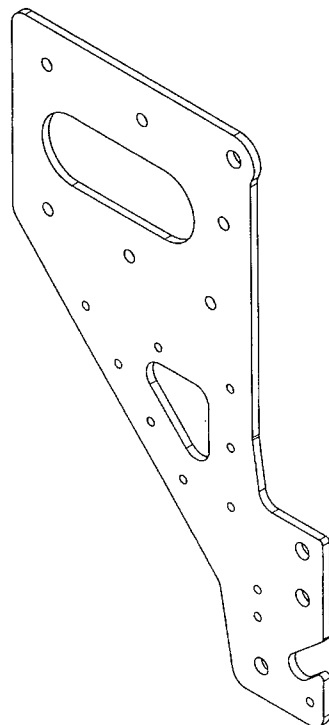
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

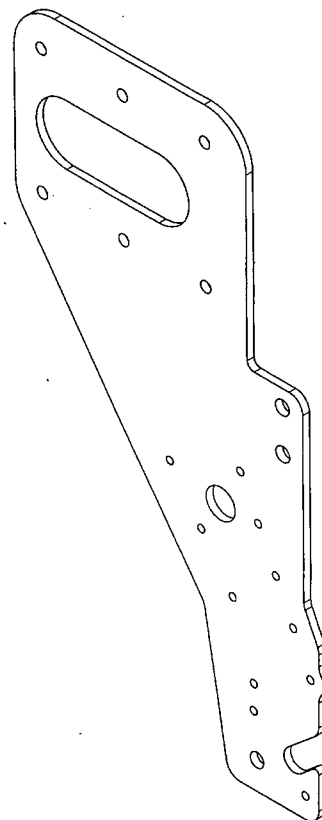
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4419-1 FWD SUPPORT PLATE



D4419-3 AFT SUPPORT PLATE

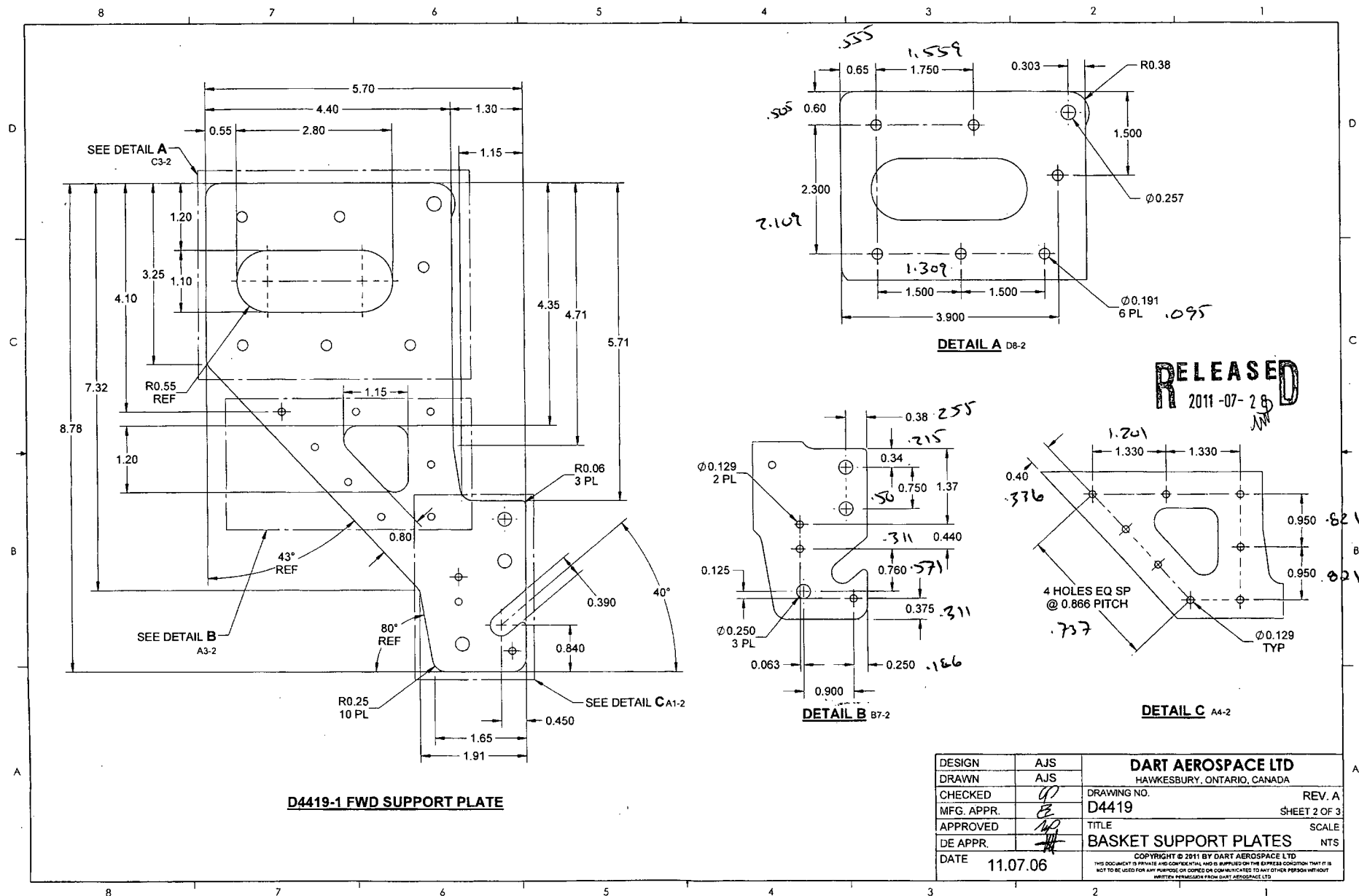
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RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 73473
CL 11/09/01

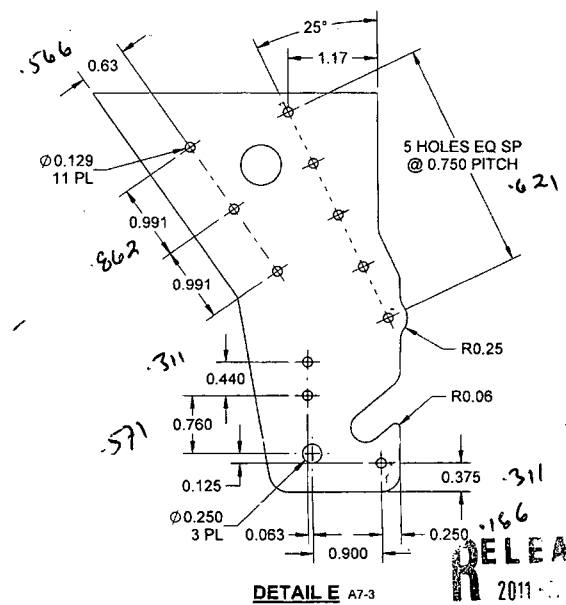
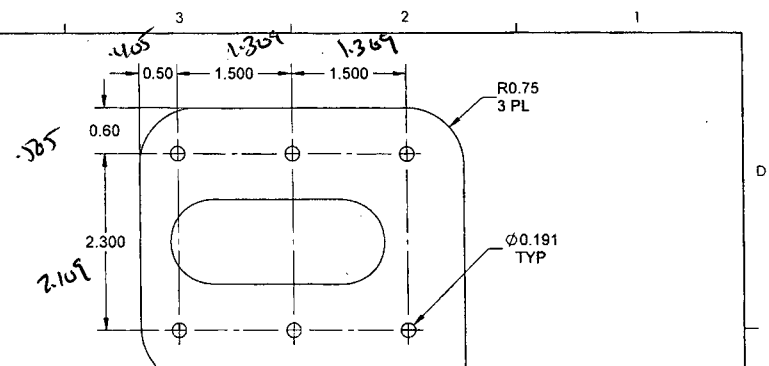
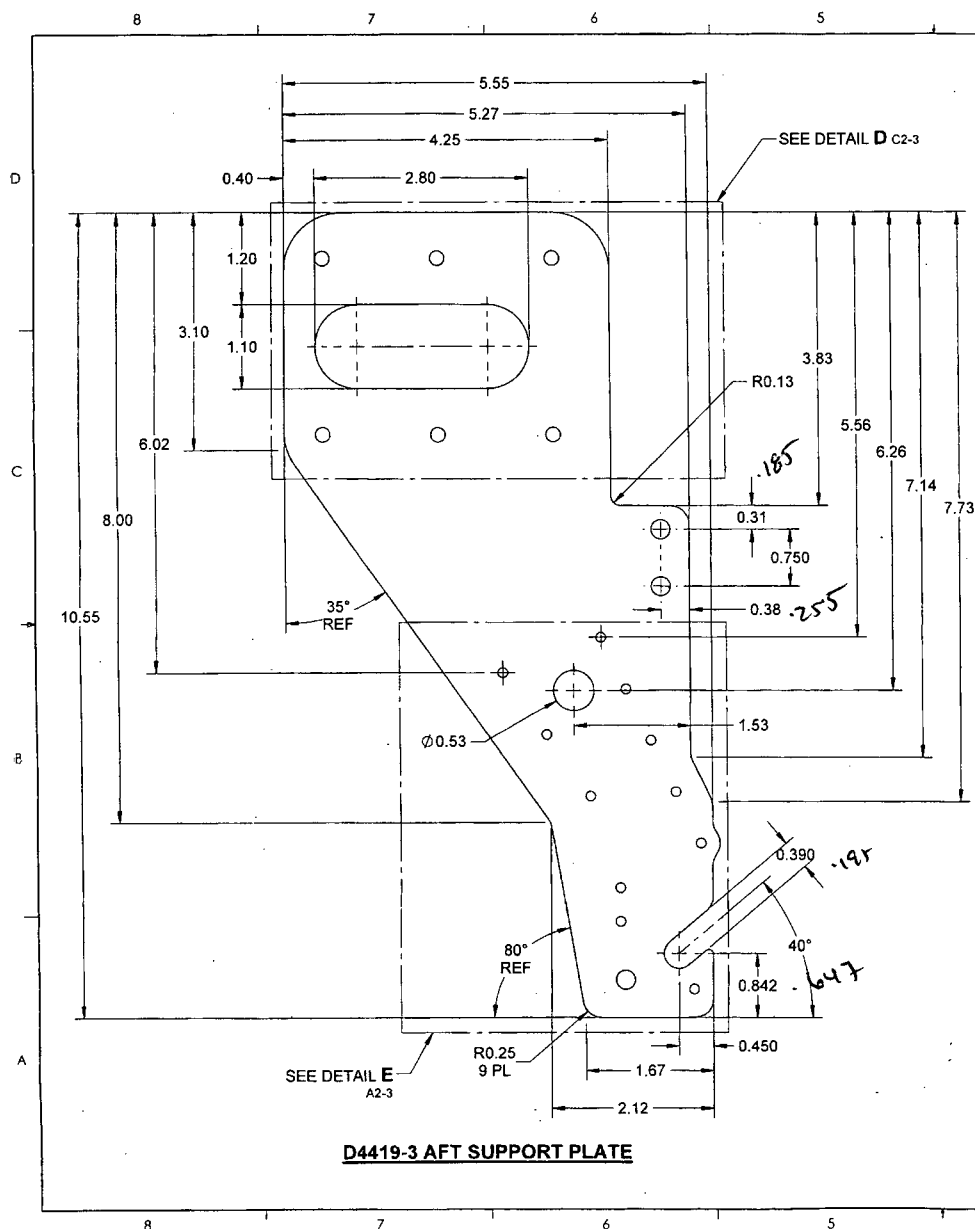
RELEASED
2011-07-28
MM

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT -1: 0.88 lbs
-3: 1.10 lbs

A		NEW ISSUE		AJS	11.07.06
REV.		DESCRIPTION		BY	DATE
DESIGN		AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN		AJS			
CHECKED		<i>[Signature]</i>		DRAWING NO.	REV.
MFG. APPR.		<i>[Signature]</i>		D4419	SHEET 1 OF 3
APPROVED		<i>[Signature]</i>		TITLE	SCALE
DE APPR.		<i>[Signature]</i>	BASKET SUPPORT PLATES	NTS	
DATE	11.07.06				
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APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET SUPPORT PLATES	NTS
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RELEASED
R 2011-11-18
JW

DART AEROSPACE LTD	Work Order: 73473
Description: AFT SUPPORT PLATE	Part Number: D4419-3
Inspection Dwg: D4419-3 Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .129	+ .005 - .001	.132	x		V HB02	
Ø .191	+ .005 - .001	.193	>		V	
Ø .250	+ .005 - .001	.250	2		V	
Ø .53	+ .008 - .001	.529	>		V	
5.55	± .03	5.537	x		V	
5.27	± .20	5.269	2		V	
4.25	± .030	4.266	2		V	
2.80	± .030	2.803	x		V	
.40	± .20	.404	2		V	
.31	± .330	.309	2		V	
.750	± .010	.748	2		V	
.38	± .030	.379	2		V	
3.83	± .020	3.840	2		V	
5.56	± .030	5.563	2		V	
6.26	± .20	6.264	2		V	
7.14	± .030	7.138	2		V	
7.73	± .20	7.728	2		V	
1.53	± .030	1.533	x		V	
.390	± .010	.387	x		V	
.842	± .010	.842	2		V	
.450	± .010	.450	2		V	
1.67	± .030	1.67	2		V	
2.12	± .030	2.121	2		V	

Measured by: RB
Date: 11-9-7

Audited by: S
Date: 11/08/06

Preliminary Approval:
Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

DART AEROSPACE LTD	Work Order: 73473
Description: AFT SUPPORT PLATE	Part Number: D4419-3
Inspection Dwg: D4419-3, Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.20	±.030	1.212	✓		✓ KB02	
1.10	±.030	1.087	✓		✓	
3.10	±.030	3.10	✓		✓	
6.00	±.030	6.025	✓		✓	
8.00	±.030	8.00	✓		✓	
10.55	±.030	10.568	✓		PROW302	
.50	±.030	.494	✓		✓	
.60	±.030	.597	✓		✓	
1.500	±.010	1.502	✓		✓	
2.300	±.010	2.303	✓		✓	
.63	±.030	.634	✓		✓	
.991	±.010	.989	✓		✓	
.991	±.010	.989	✓		✓	
.440	±.010	.440	✓		✓	
.760	±.010	.754	✓		✓	
.125	±.010	.130	✓		✓	
.063	±.010	.060	✓		✓	
.900	±.010	.900	✓		✓	
.250	±.010	.250	✓		✓	
.375	±.010	.376	✓		✓	
.750	±.010	.749	✓		✓	
.025	±.010	.117	✓		✓	

Measured by: RB	Audited by: S	Prototype Approval:
Date: 11-9-7	Date: 4/6/08	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	